

Page 1

October 15, 2009 11:10:31 AM

Item ID:

D2327-1

D **Revision ID:**

Required Date: 23/10/2009

Item Name:

Snacer Bushing

Start Date:

15/10/2009

Req'd Qty: 20.00



Accept

Start Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date 09-10-15

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Stop

Setup Start

Stop

Sequence ID/ Work Center ID Operation Description

Revision Nbr

Set Up/ **Run Hours** Draw Number

Plan Draw Code Rev.

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

D2327

Rev D

100

' Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

Turn per Folio FA232 and Dwg D2327 □Deburr

0.00

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

1101/0 1200116

0.00

120

Quality Control

QC8- Inspect parts - second check

Memo

0.00 and oalio/16

0.00

Work Order ID 52832

D



Page 2

October 15, 2009 11:10:31 AM

Required Date: 23/10/2009

Item ID:

D2327-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Spacer Bushing 15/10/2009

Start Qty: 20.00

Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

Date:

Run

Start



SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID**

130

Operation Description

Identify as per dwg & Stock Location: Dage

Set Up/ **Run Hours**

0.00

Draw Number

Plan Draw Code Rev.

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Packaging

0.00

09.10.19

Packaging

140

Quality Control

OC21- Final Inspection - Work Order Release

Memo

Memo

0.00

0.00

Picklist Print

October 15, 2009 11:10:37 AM

Work Order ID: 52832

Parent Item:

D2327-1RevD

Parent Item Name: Spacer Bushing

Comments:



Start Date: 15/10/2009

Required Date: 23/10/2009

Page 1

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/	Replacement	Mfg/	Bin Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M304R0.375		Purchased	No		100	f	49.8845	3.7284			·

304 ROUND BAR 0.375

<u>Warehouse</u>	Loc Qty	Loc Code		
Location				
Main Warehouse				
MAT	49.88447895			
110166	3.32			
110472	6.41			
112058	0.31317895			
 112473	39.8413			

442 5/08/0/16

DART AEROSPACE LTD	Work Order: 62832
Description: Space 1 125hing	Part Number: 1) 32 7 - /
1	
Inspection Dwg: 2327-1 Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

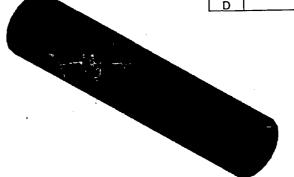
	X	First Artic	:le	Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Соп	nments
2,000	±.010	2,001					
0.375	0/0	0.373	**			Mat.	stock
0.257	4.006	0.257					
						·	
							,
		*		·			
Measured by:	12	Audited by:	and		Prototype Ap	oproval:	N/A
	61.0111	Date:	nalin h	-		Date:	N/A

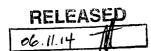
Date. 01016					
Rev	Date	Change	Revised by	Approved	
Δ	Date	New Issue	KJ/JLM		
		14044 13346			



DEGIGNI	DRAWN BY	DART AFROCA	CELTD
DESIGN BW	CB	DART AEROSPA HAWKESBURY, ONTARIO	
CHECKED	APPROVED	DRAWING NO.	REV. D
	1 94	D2327	SHEET 1 OF 1
DATE		TITLE	SCALE
06.	.10.12	SPACER BUSHING	2:1

1			
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
В	95.12.06	LENGTH CHANGE	
c	03.05.13	303 SS SPEC ADDED	
n l	06 10 12	REMOVE 303 SS MATERIAL	

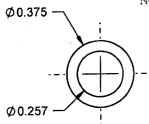




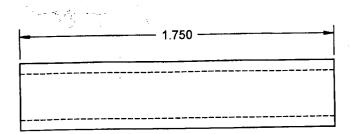
SHOP COP RETURN TO ENGINEERING UNCONTROLLED COM SUBJECT TO A 1978 WITHOUT BOY

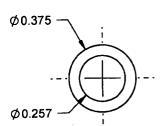
WORK OR IR NO. 52832

2.000 ———	•



D2327-1 SPACER BUSHING





D2327-3 SPACER BUSHING

1) MATERIAL: AISI 304/316 SS, Ø 0.375, 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC M304TR0.375W.065)

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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